

Date: Monday, 25/05/2009 10:53:16 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 48178	
Estimate Number : 13066	
P.O. Number :	Part Number : D36811
This Issue : 25/05/2009 S.O. No. :	Drawing Number : D3681 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 47123	Material :
Written By :	Due Date : 01/06/2009 Qty: 60 Um: Each
Checked & Approved By : MF 09-05-25	
Comment : Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w
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Comment: Qty.: 0.3570 f(s)/Unit Total : 14.2800 f(s)

Material:

(M6061T6T0.313W.058)

Batch: M111874

21.5 ft

SA 09/05/28

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: A

DWG REV: A

2-DEBURR AS REQUIRED

SA 09/05/28

61

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/05/28

61

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/05/28

61

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 09/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 25/05/2009 10:53:16 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 48178

Part Number: D36811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/09 *[Signature]*

Job Completion



MF
09-06-08

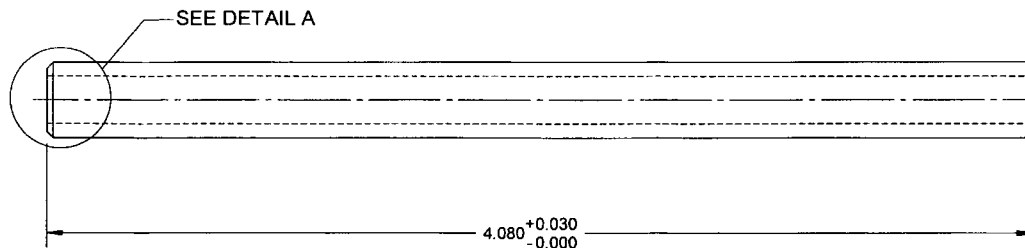
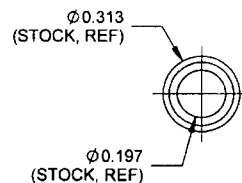
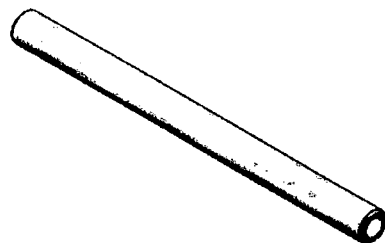
W/Q:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

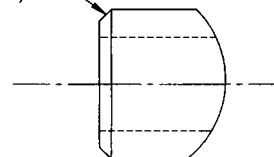
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3681-1 SPACER

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

48178

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
07-11-09

A		NEW ISSUE		DC	07.11.08
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	SC				
CHECKED	MS	DRAWING NO.	D3681	REV. A	
MFG. APPR.	REP			SHEET 1 OF 1	
APPROVED	REP	TITLE	SPACER	SCALE	2:1
DE APPR.	#				
DATE	07.11.08	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			